

Date: Thursday, 11/29/2007 11:09:45 AM
 User: Kim Johnston

Process Sheet

52

| | |
|--|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : 206L AFT X-TUBE |
| Job Number : 36056 | |
| Estimate Number : 10973 | |
| P.O. Number : <u>N/A</u> | Part Number : D206667203 |
| This Issue : 11/29/2007 S.O. No. : <u>N/A</u> | Drawing Number : D206-667-243 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <u>N/A</u> Type : LANDING GEAR | Drawing Revision : B |
| Previous Run : 35306 | Material : <u>N/A</u> |
| Written By : <u>[Signature]</u> | Due Date : 12/24/2007 Qty: 1 Um: Each |
| Checked & Approved By : <u>[Signature]</u> | |
| Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell Skidtubes KJ/JLM | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

| | | |
|-----|----------|--------------------|
| 2.0 | D6004115 | Crosstube material |
|-----|----------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| | | | |
|-----|-------------|-------------|----------------|
| Qty | Part number | Description | Batch |
| 1 | D6004-115 | Crosstube | <u>B 32305</u> |

Check OD = 2.500"; ID = 1.800"

J.F. 07/12/06

| | | |
|-----|------------|----------------------------|
| 3.0 | MORI SEIKI | MORI SEIKI CNC LATHE LARGE |
|-----|------------|----------------------------|



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

J.F. 07/12/07 ①

| | | |
|-----|-----|------------------------------|
| 4.0 | QC1 | INSPECT ALL DIM TO DIM SHEET |
|-----|-----|------------------------------|



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/07 ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36056

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA089

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

3-Remove sand and plugs

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-243

Inside of Cuff(Donot engrave on outside of tube)

J.F. 07/12/07 ①

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/12/07 ①

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

OK 07/12/07 ①

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

ALM 07-12-10

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 7-12-10

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ID/EL 7-12-10

11.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D206-667-243 using CNC bender program 206L-AF and Folio FT

EL 7-12-11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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QA: N/C Closed: _____ Date: _____

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Date: Thursday, 11/29/2007 11:09:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36056

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

7/12/11 (X)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill all (3) top holes.

2-Drill and Ream all holes in tube to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243
Check dimensions between holes on all four sides.

3-Flip tube and switch drilling Jigs from right to left, left to right. Locate Jigs off existing holes using "T" pins.

4-Drill pilot holes using drill Jig DT8583 & DT8584 as per Dwg D206-667-243. Drill only the top (2) holes.

5-Drill & ream the top (2) holes to finish size using drill Jig DT8583 & DT8584 as per Dwg D206-667-243

6-Drill Fwd rivet holes using drill Jig DT8789FWD as per Dwg D206-667-143. Note: Fwd side has 3x top holes.

7-Drill Aft rivet holes using drill Jig DT8789 as per Dwg D206-667-243.

8-C'sink holes as per Dwg D206-667-243.

9-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243

AWM 07-12-12

SR

7-12-11

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 07-12-12

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/12/13 (X)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/13 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36056

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038Or

Issue P/O: 5299

LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

07/12/17 (1)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

07/14/17 (1)

19.0

QC6

DIMENSIONAL CHECK



Comment: Inspect for damage & ensure results are as per Dwg D206-667-103

07-12-18 (1)

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Mask Threaded holes

2-Prime inside and outside crosstube as per QSI 005 4.2

3-Paint outside crosstube with White Imron as per QSI 005 4.2

07-12-15

21.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

07-12-17 (1)

22.0

D2873045

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-045

Nut Plate

34077

07-12-15

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36056

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

D2873043

Nut Plate Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2873-043

Nut Plate

33422 / 34061

85 07-12-15

24.0

MS20601AD4W10

RIVET



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick:

Qty Part number Description Batch

14 MS20601AD4W10 Rivet

104885

85 07-12-15

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install nut plates as per Dwg D206-667-243.

85 07-12-15

26.0

D2856400

Abrasion Strip



Comment: Qty.: 1.3525 f(s)/Unit Total : 1.3525 f(s) (cut to 4")

Pick:

Qty Part number Description Batch

2 D2856-400 (cut to 7.73")

Abrasion Strip

25656

ml 07 12 17

27.0

D28921

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2892-1

Support

34063

ml 07 12 17

28.0

MS2192022

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-22

Clamp

105066

ml 07 12 17

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36056

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install abrasion strips as per QSI 035 using DT8580. Note: (3) top holes should be facing up.

2-Install supports and clamps as per Dwg D206-667-243. Torque clamps to 80-100 in lb

ml
07/12/17 (1)

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/12/20 (XU)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

32.0

AN534A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

M105408

AS 07/12/20 (XU)

33.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch:

M105430

AS

34.0

AN510A

Bolt



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

10 AN5-10A

Bolt

M104679

ALL SAME

AS

35.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part number

Description Batch

M105408

AS 07/12/20 (XU)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: RD Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:09:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L AFT X-TUBE

Job Number: 36056

Part Number: D206667203

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 AN5-32A

Bolt

36.0

AN960JD516

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part number Description Batch

18 AN960JD516 Washer

M104156

AS 04/12/20

(X1)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

kit wrapped in box

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-667-203

Location:

PPP Rev:

RevC

AS

04/12/27

54

(X1)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/01/03

Job Completion



2008/1/3
u

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| | |
|--|----------------------------------|
| DART AEROSPACE LTD | Work Order: 36056 |
| Description: Crosstube Assembly | Part Number: D206-667-243 |
| Inspection Dwg: D206-667-243 Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

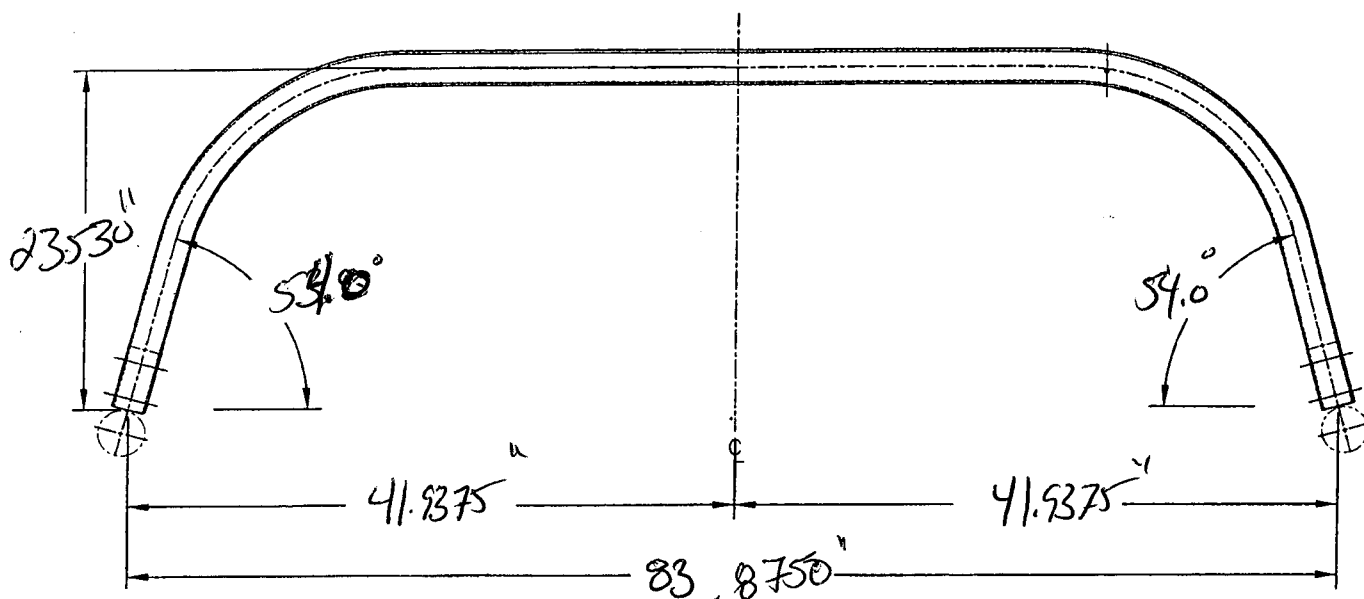
| Inspection Sheet Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---------------------------------------|-------------|---------------------|------------|--------|-------------------------|----------|
| SIDE A | 2.490 | +0.005/-0.000 | 2.492" | ✓ | | |
| | 2.018 | +0.005/-0.000 | 2.023" | ✓ | | |
| | 2.079 | +0.005/-0.000 | 2.084" | ✓ | | |
| | 2.145 | +0.005/-0.000 | 2.150" | ✓ | | |
| | 2.209 | +0.005/-0.000 | 2.214" | ✓ | | |
| | 2.287 | +0.005/-0.000 | 2.290" | ✓ | | |
| | 2.363 | +0.005/-0.000 | 2.365" | ✓ | | |
| | 2.433 | +0.005/-0.000 | 2.436" | ✓ | | |
| | 0.200 | +/-0.010 | .200" | ✓ | | |
| | 0.500 x 30° | +/-0.010 | .500 x 30° | ✓ | | |
| | R0.063 | +/-0.010 | R0.063" | ✓ | | |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | |
| | 4.438 | +/-0.030 | 4.440" | ✓ | | |
| | | | | | | |
| | | | | | | |
| SIDE B | 104.91 | +/-0.020 | 104.910" | ✓ | | |
| | | | | | | |
| | 2.490 | +0.005/-0.000 | 2.494" | ✓ | | |
| | 2.018 | +0.005/-0.000 | 2.023" | ✓ | | |
| | 2.079 | +0.005/-0.000 | 2.084" | ✓ | | |
| | 2.145 | +0.005/-0.000 | 2.150" | ✓ | | |
| | 2.209 | +0.005/-0.000 | 2.214" | ✓ | | |
| | 2.287 | +0.005/-0.000 | 2.290" | ✓ | | |
| | 2.363 | +0.005/-0.000 | 2.364" | ✓ | | |
| | 2.433 | +0.005/-0.000 | 2.435" | ✓ | | |
| | | | | | | |
| | 0.200 | +/-0.010 | .200" | ✓ | | |
| | 0.500 x 30° | +/-0.010 | .500 x 30° | ✓ | | |
| | R0.063 | +/-0.010 | R0.063" | ✓ | | |
| | R0.500 | +/-0.010 | R0.500" | ✓ | | |
| | 4.438 | +/-0.030 | 4.443" | ✓ | | |
| | | | | | | |

| | | | |
|--------------------------|--------------------------------|----------------------------|-----|
| Measured by: J-F. | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 07/12/07 | Date: 07/12/10 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------------------|--------------------|-------------|
| A | 06.09.01 | New Issue (P/O D206-667-203) | KJ/JLM [Signature] | [Signature] |

| | | | |
|--|--|--------------|--------------|
| DART AEROSPACE LTD | | Work Order: | 36056 |
| Description: Crosstube High Aft (206L) | | Part Number: | D206-667-203 |
| Inspection Dwg: D206-667-243 Rev: B | | Page 1 of 1 | |

| Required Dimension | Min | Max |
|--------------------|-------|-------|
| Height | 23.46 | 23.58 |
| 1/2 Span | 41.86 | 41.98 |
| Angle | 54 | 56 |
| Total Span | 83.72 | 83.96 |



| Comments |
|----------|
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|-----------------|---------|
| QC15 Inspection | 2/12/14 |
| Date | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 07.02.06 | New Issue | KJ/JM | <i>[Signature]</i> |



| | | | |
|------------------|------------------|---|------------------------|
| DESIGN PH | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # DS | APPROVED # DS | DRAWING NO. D206-667-243 | REV. B SHEET 1 OF 3 |
| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH AFT) | SCALE NTS |
| A | 00.11.17 | NEW ISSUE | |
| B | 05.07.26 | ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES | |

RELEASED
05-07-26

UNDER REVIEW

06-08-10 RH

re draw detail F

RH

07.05.02

| Qty | Part Number | Description |
|-----|---------------|--------------------------|
| X | D206-667-243 | CROSSTUBE ASSEMBLY |
| 1 | D6004-115 | CROSSTUBE |
| 2 | D2856-400-773 | ABRASION STRIP |
| 2 | D2873-043 | NUT PLATE |
| 2 | D2873-045 | NUT PLATE |
| 2 | D2892-1 | SUPPORT |
| 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 4 | MS21920-22 | CLAMP |

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 104.91±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-773 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2892-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) IT IS OPTIONAL TO SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

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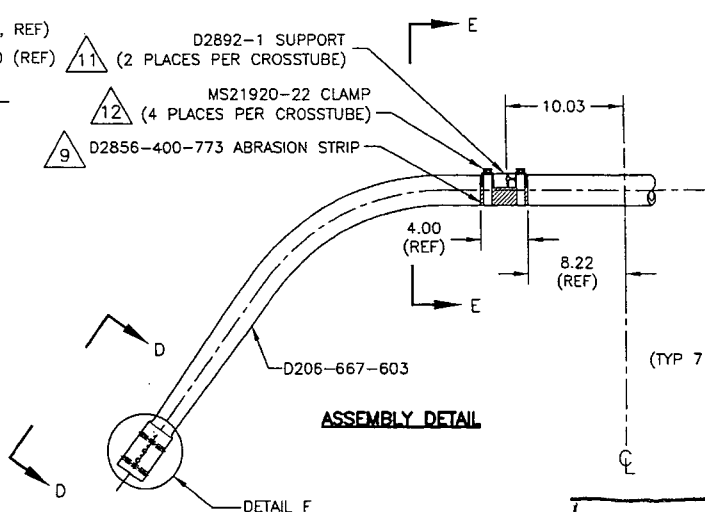
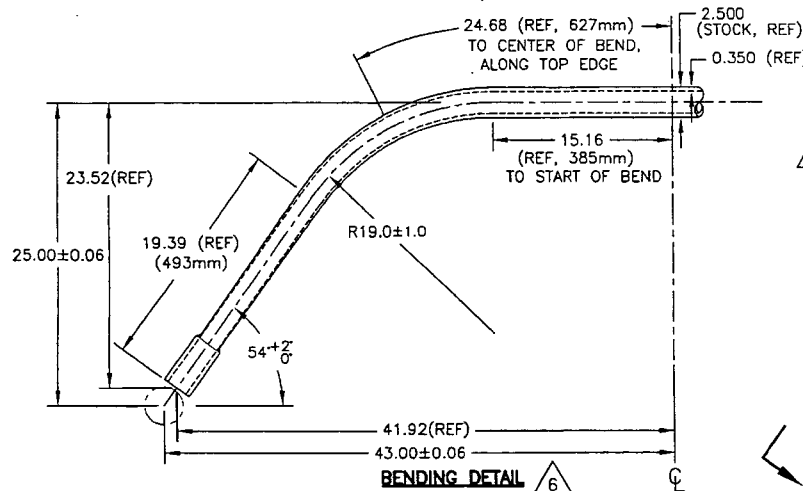
SUBJECT TO AMENDMENT

WORK ORDER

NO. 36036

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B $\varnothing 0.323^{+0.005}_{-0.000}$
(TYP 5 PLACES PER CUFF)
HOLE TO BE ALIGNED WITHIN ± 0.001 OF HOLE ON OTHER SIDE OF CUFF

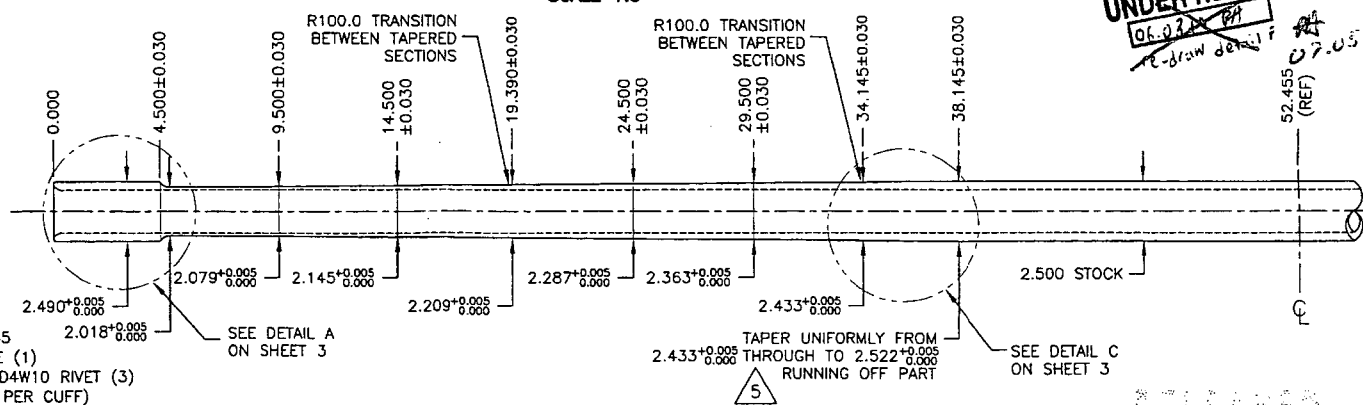
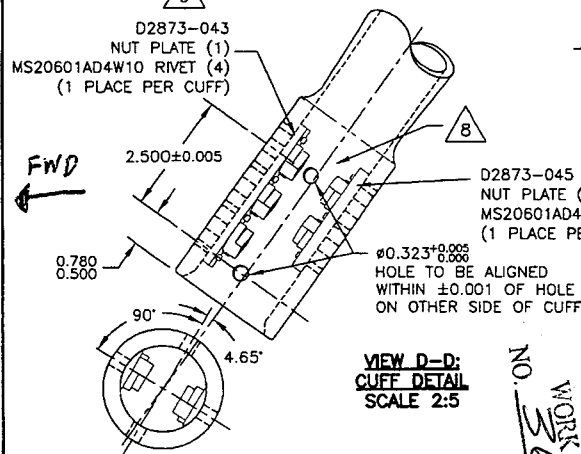
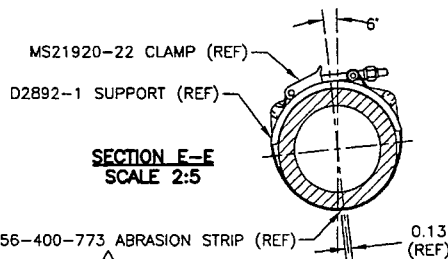
PILOT $\varnothing 0.128$
C'SINK $\varnothing 0.225 \times 100^\circ$
(TYP 7 PLACES PER CUFF)

FWD SIDE ONLY

DETAIL F
SCALE 2:5

UNDER REVIEW
06.03.26 PH
re-draw detail F

FWD SIDE ONLY



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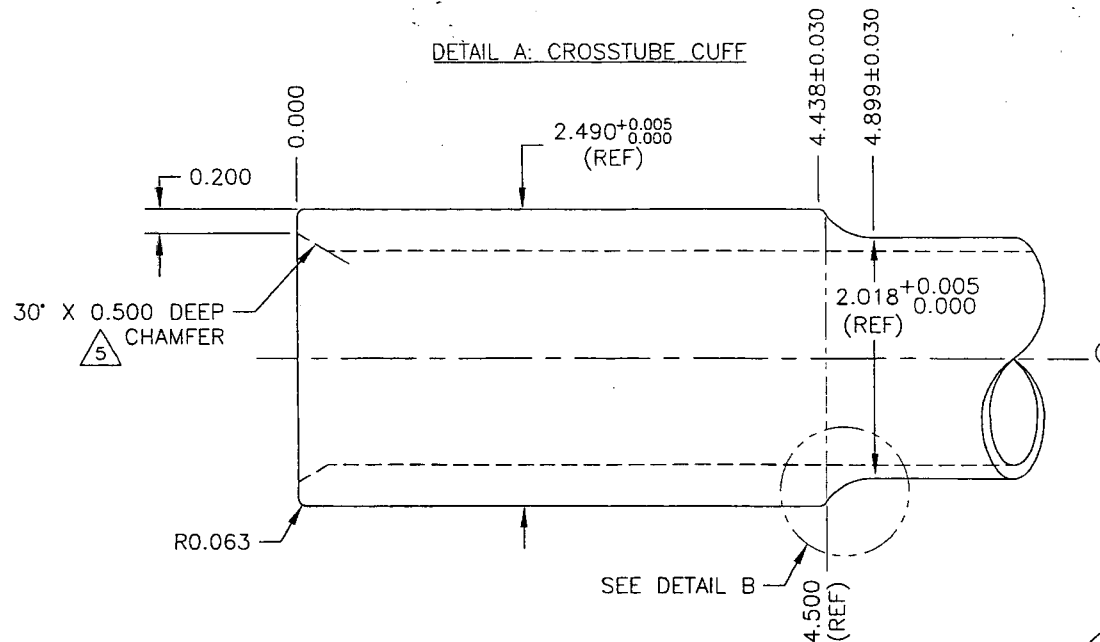
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| | | | | | |
|---------|----------|----------|---------------------------------|-------------|---|
| DESIGN | PH | DRAWN BY | PH | DART | DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA |
| CHECKED | DS | APPROVED | DS | DRAWING NO. | D206-667-243 |
| DATE | 05.07.26 | TITLE | CROSSTUBE ASS'Y (206L HIGH AFT) | SCALE | 1:10 |

REV. B
SHEET 2 OF 3

NO. 36056
WORK ORDER
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DETAIL A: CROSSTUBE CUFF



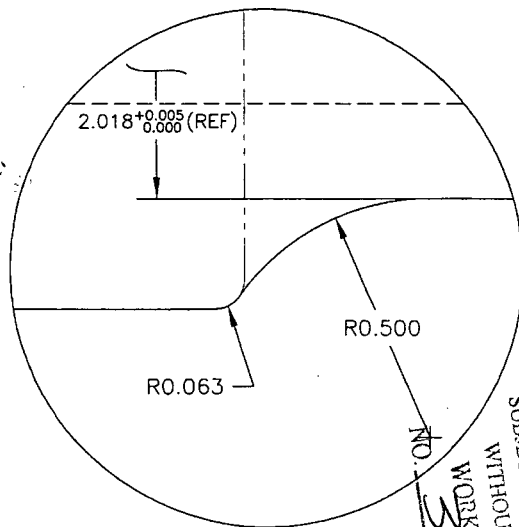
05.07.26 #

UNDER REVIEW

06.03.26 PH

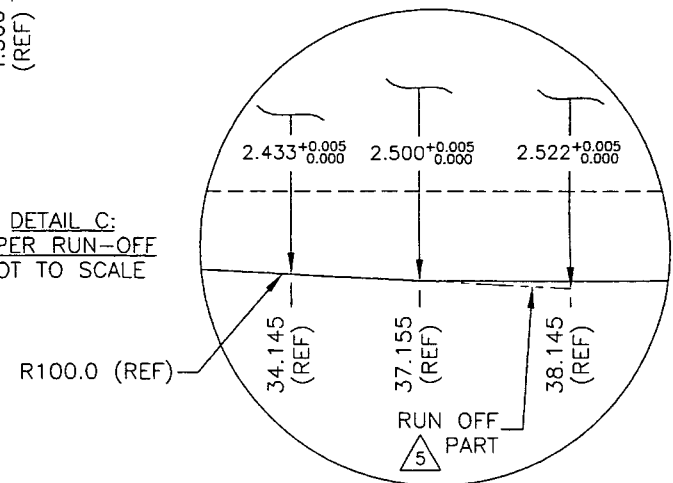
Re-draw detail if

PH 07.05.02



DETAIL B: CUFF
TRANSITION
SCALE 4:1

DETAIL C:
TAPER RUN-OFF
NOT TO SCALE



NO. 36056

WORK ORDER

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| | | PH | PH | HAWKESBURY, ONTARIO, CANADA | |
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| DATE 05.07.26 | | TITLE CROSSTUBE ASS'Y (206L HIGH AFT) | | | SCALE 1:1 |



LIQUID PENETRANT TEST REPORT

P - 7-1055

PAGE 1 OF 1
TIME AM ☐ PM ☐

CLIENT DART AREOSPACE DATE DEC. 14, 2007
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-7-01055
ADDRESS 1270 ABERDEEN ST. HAWKESBURY ONT. POWO No. 5259
WORK LOCATION HAWKESBURY
ACCEPTANCE STD. ASTM 1417/QSI-038 REV./DATE 2005
PROJECT 212/205 HIGH FED X-TUBE, 206L FWD X-TUBES, 206BAFT X-TUBES, 206L AFT X-TUBES
ITEM(S) EXAMINED JOB #'S 35725, 35893, 36051, 36053, 36055, 36056, 36057, 36059,

JOB DESCRIPTION PROCEDURE NO. LT-0002 REV./DATE TECHNIQUE NO. LT-0002-02 REV./DATE
Part No. D206667201, D206667203, D212664101, D206667103 Material ALODYNED ALUMINUM Thickness
Scope WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% OF EXTERNAL SURFACE.

TEST DETAILS

| | | | | | |
|-------------------|---|----------------------------------|--|--|---|
| Method | <input checked="" type="checkbox"/> Fluorescent | <input type="checkbox"/> Visible | <input checked="" type="checkbox"/> Water Wash | <input type="checkbox"/> Solvent Removable | <input type="checkbox"/> Post Emulsified |
| Family Brand | MAGNAFLUX | | Black Light S/N | 8178 | <input checked="" type="checkbox"/> Output > 1000 μ W/cm ² |
| Penetrant | ZL67 | Minimum Dwell time | 45 | Min. | <input checked="" type="checkbox"/> Ambient < 2 fc |
| Penetrant Remover | H20 | Minimum Dry time | >10 | Min. | <input checked="" type="checkbox"/> Output > 100 fc @ surface |
| Developer | SKDS2 | Minimum Dwell time | 10 | Min. | |
| Developer Type | <input checked="" type="checkbox"/> Non Aqueous | <input type="checkbox"/> Aqueous | <input type="checkbox"/> Dry | | Cal Due Date MAR 08 |

TEST SURFACE

| | | | | | |
|---------------------|---|---|---|---------------------------------------|---|
| Surface Condition | <input checked="" type="checkbox"/> As Ground | <input type="checkbox"/> As Welded | <input checked="" type="checkbox"/> Machined | <input type="checkbox"/> Shot Blasted | <input type="checkbox"/> Clean Bare Metal |
| Surface Temperature | <input type="checkbox"/> < - 4°C/ 20°F | <input type="checkbox"/> - 4°C/ 20°F to 10°C/50°F | <input checked="" type="checkbox"/> 10°C/50°F to 52°C/125°F | <input type="checkbox"/> > 52°C/125°F | |

RESULTS- (☐ METRIC ☐ IMPERIAL)

| item | Comments | Accept | Reject |
|------|---|--------|--------|
| | F.L.P.I. CARRIED OUT ON 100% OF EXTERNAL SURFACE OF: 212/205 HIGH FED X-TUBES JOB# 35893 | | |
| | 206B AFT X-TUBES JOB #'S 36051, 35725 | | |
| | 206L FWD X-TUBES JOB#'S 36053, 36055 | | |
| | 206L AFT X-TUBES JOB #'S 36057, 36059, 36056 | | |
| | RESULTS: 206B AFT X-TUBE #36051 HAS ROUGH GRINDING MARKS. TO BE POLISHED AND RECHECKED AT A LATER DATE. | | |
| | ALL OTHER JOB #'S ARE ACCEPTABLE TO ASTM 1417/ QSI-038 STANDARD. | | |

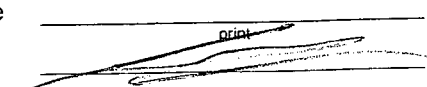
Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

| Client Representative | Technician (Signature): | DTR # |
|---------------------------------|---|---------------------|
| |  | Report Reviewed by: |
| Name (Print): FREDERICK CHAGNON | signature BRENDON MIRAN | Name initials |
| CGSB Level II SNT Level | 2 nd technician | |
| CGSB Reg. No 10560 | CGSB Level II SNT Level | |
| | CGSB Reg. No 12247 | |

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Date: Thursday, 11/29/2007 11:09:45 AM
User: Kim Johnston

Process Sheet

52

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L AFT X-TUBE
Job Number : 36056
Estimate Number : 10973
P.O. Number :
This Issue : 11/29/2007 S.O. No. :
Prsht Rev. : NC Part Number : D206667203
First Issue : 11 Type : LANDING GEAR Drawing Number : D206-667-243 REV B
Previous Run : 35306 Drawing Revision : B
Material :
Written By : Due Date : 12/24/2007 Qty: 1 Um: Each
Checked & Approved By : 07.11.29
Comment : Est Rev: F 05.09.01 Add holes for compatibility with Bell
Skidtubes KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D206-667-203 CHG002

07.12.07

2.0 D6004115 Crosstube material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6004-115 Crosstube

Check OD = 2.500"; ID = 1.800"

3.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA089

2-Turn first side as per Folio FA089

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D206-667-243.

REFERENCE ONLY

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET